

Work Order ID 65556

January 19, 2011 1:42:57 PM



Page 1

Item ID: D3651-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Base

Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: YMF Date: 11-01-19

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 1 Dwg Rev: B 1 Prog Rev: B 1 2-

304 . 018

Deburr if necessary

B11-1-26

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-26

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/1/127

(46)

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Setup Start



Revision ID:

Stop



Item Name: Base

Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Sp 11/02/03



Brake NC

Form as per Dwg D3651

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

S 1/02/04



Quality Control

150

0.00



Identify as per dwg & Stock Location: 188

Packaging

Memo

0.00

1/2/04

Packaging

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Accept



Setup Start



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Item Name: Base

Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/07

MF

11-02-04

Picklist Print

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Work Order ID: 65556



Parent Item: D3651-3



Parent Item Name: Base

Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA

Purchased

No

100

sf

109.6600

0.474

1.995789



304/316 0.018 SHEET



11-1-26

Location

Loc Qty

Loc Code

MAT20

109.66

109398

20.06

112885

89.6

112885

6

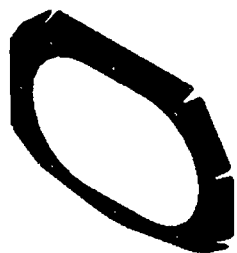
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

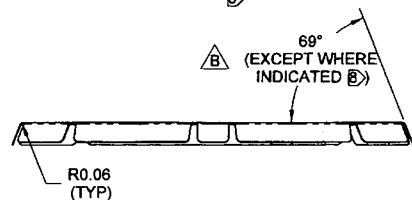
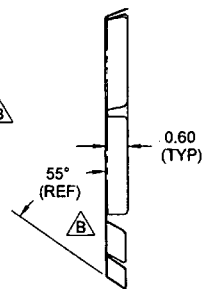
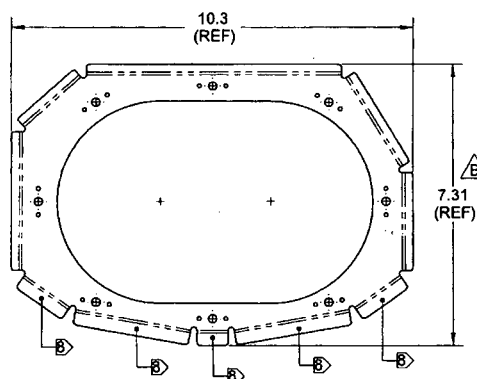
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

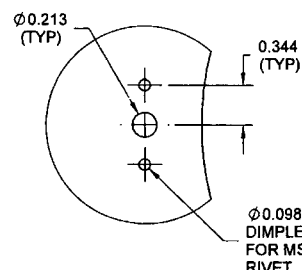
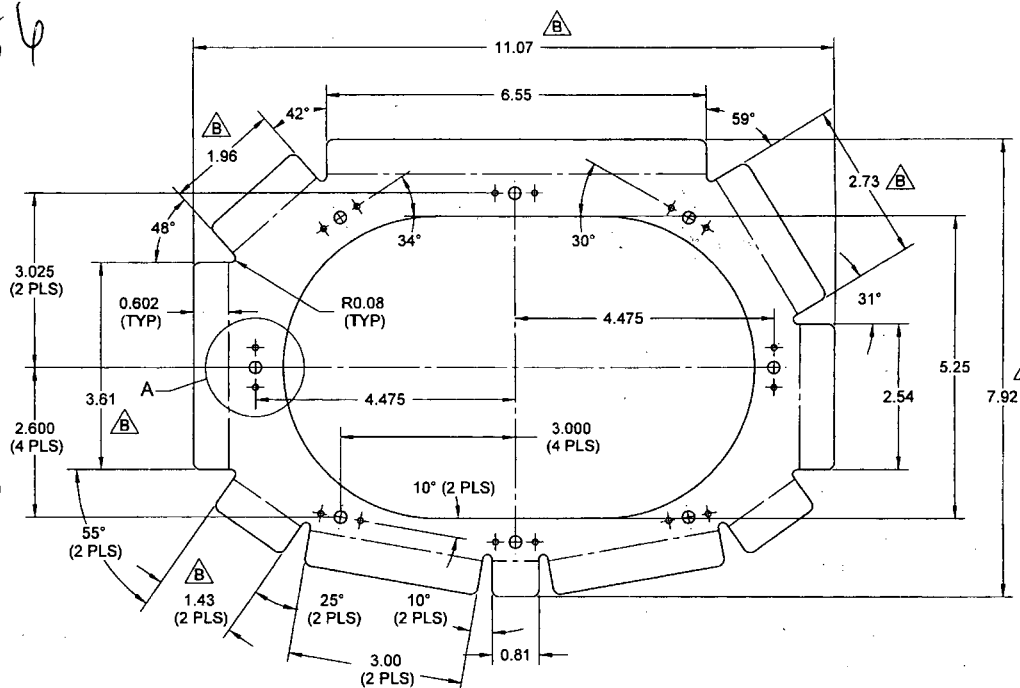
NOTE: Date & initial all entries



6555 6



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)





DETAIL A

D3651-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs
8) BEND TO 55° WHERE INDICATED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3651 TITLE AFT BASE ASSEMBLY COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND NOT BE LOANED OR THE EXPRESS CONSENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN AND SIGNED PERMISSION FROM DART AEROSPACE LTD.	REV. B
DRAWN	RF		SHEET 4 OF 9
CHECKED	LE		SCALE
MFG. APPR.			1:2
APPROVED			
DE APPR.			
DATE	08.01.07		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries